Memo

Quality Control

January 5, 2010 11:28:00 AM D3788-3 Accept Setup Start Item ID: Revision ID: Stop Cabin Floor Protector Item Name: Cist Item ID: **Start Date:** Required Date: 18/01/2016 Req'd Qty: : ustomer: Reference: Start Run Tooling: **Process Plan:** Approvals: Stop SPC (Y/N): Date: QC: Date: Operation Draw Draw Plan Accept Reject Sequence ID/ Set Up/ Description **Run Hours** Number Rev. Code Otv Oty Number Stamp Work Center ID Draw Nbr **Revision Nbr** : D3788 Rev A 100 0.00 FLOW WATER JET - B 10-1-14-0.00 Waterjet Memo 1-Cut as per Dwg D3788 Dwg Rev: FLOW CNC Waterjet Deburr if necessary 10-01-15 0.00 110 QC2- Inspect parts off machine FAI/FAIB B104-14 0.00 Memo Quality Control QC8- inspect parts - second check 120 2) Siblocky

Dart Ae	rospace	e Ltd						3 ~
W/O:			WO	RK ORDER CHANGE	ES		•	· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	CEDURE CHAN	NGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
a = 1.								į
د: ,	4 . 4 · L			* */				
					,			
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposition	):	QA: N/C Cld	sed:	Date: _	<del></del>
NCR:		V	VORK ORDE	R NON-CONFORMA	NCE (NCR	)		
DATE	CTED	Description of NC	1	Corrective Action Section		Verification	1 Approvai	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
	ļ.							
	<del> </del>	· · · · · · · · · · · · · · · · · · ·						

#### Work Order ID 54979

January 5, 2010 11:28:01 AM



Item ID: D3788-3

**Revision ID:** 

Item Name: Cabin Floor Protector

**Start Date:** 

05/01/2010 Start Qty: 3.00 Required Date: 18/01/2010 Req'd Qty: 3.00



Accept



Setup Start

Stop

Cast Item ID:

徽ustomer:



Reference:

Approvais:

Process Plan:

Date:

Date: \_\_\_\_\_

Tooling:

0.00

0.00

SPC (Y/N):

Date:

Date:

Run

Start



Sequence ID/ Work Center ID

130

Small Fab Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours** 

Draw Number Rev.

Plan Code

Accept Oty

Reject Reject Qty

Number Stamp

QC5- Inspect part completeness to step on W/O

Deburr if necessary.

2) Sulvel15

10-01-15

0.00

QC

Quality Control

Memo

Memo

150

140

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

W/O: WORK ORDER CHANGES						
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				:		
				-		
,	,		•			
	STEP		STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

		WORK OR	DER NON-CONFORMANC	CE (NCR)						
	Description of NC		Corrective Action Section B			Annroyal	Approval			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
	100 Maria Maria 100 Maria									
			,							
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng			



January 5, 2010 11:28:01 AM

Item ID:

D3788-3

Accept



Setup Start



Stop



Revision ID: Item Name:

Cabin Floor Protector

**Start Date:** 

05/01/2010 Start Qty: 3.00 Required Date: 18/01/2010 | geq'd Qty: 3.00

Cust Item ID:

Castomer:

Number

Reference:

Approvals:

Date:

Tooling:

Date:

Start Run



Process Plan:

Date:\_\_\_\_\_

SPC (Y/N):

Set Up/

Date:

Draw

Rev.

Plan

Code

Stop

Sequence ID/

Work Center ID

160

QC

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Run Hours

0.00

0.00

Accept Qty Qty

Reject

Reject Number Stamp

Quality Control

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
_					-	i	
. *=							
Dort No							l

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
•	Resolution:		Disposition:	QA: N/C Closed	:	Date:	

NCR:			WORK ORDI	ORK ORDER NON-CONFORMANCE (NCR)						
	T	Description of NC Corrective Action Section B			Verification	Annroyal	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector		
,										

#### **Picklist Print**

January 5, 2010 11:28:04 AM

Work Order ID: 54979

Parent Item:

D3788-3

Parent Item Name: Cabin Floor Protector

Comments:

Component Item ID/	Replaceratift	Mfg
Item Name	Item ID	Purc

rch

Bin

Primary Last Item Location Location Route Seq ID

100

Lau of Masure Hand

Qty on Remaining Qty To Pick Issued

1,989.831 31.5789

Start Qty: 3.00

Start Date: 05/01/2010

Date Issued

Required Date: 18/01/2010

Required Qty: 3.00

Status

MLEXS.125-F60029-04

Purchased

GE PLASTICS LEXAN SHEET

B10-1-4

Warehouse	Loc Qty	Loc Code		
Location				
Main Warehouse				
MAT	1989.831798			
103106	1.6765			
105330	47.8767			
109455	40.5717			
111710	<b>329.89</b> 3632			
112585	1569.81327		112585	

Page 1

W/O:		WORK ORDER CHA	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
4.4							
Part No	):	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date:	

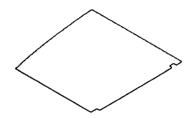
Resolution:		olution:	Disposition	າ:	_ QA: N/C Clos	sed:	Date: _	
			WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
		Description of NC	Description of NC Corrective Action		on B	Verification	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
						į		
NOTE: D	ate & initial a	all entries				I	<u> </u>	1

DART AEROSPACE LTD	Work Order:	54979
Description: Cabin Floor Protector	Part Number:	D3788-3
Inspection Dwg: D3788 Rev: A		Page 1 of 1

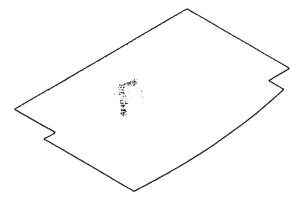
	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	x	First Artic	:le	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method Inspecti		nments
32.15	+/-0.030	39,15	<b>A</b>				
2.00	+/-0.030	3,00	8				
1.50	+/-0.030	1.50	8				
1.00	+/-0.030	1.00	a				
31.50	+/-0.030	31.50	n				
2.13	+/-0.030	2.13	r				
1.00	+/-0.030	1.00	8				
27.69	+/-0.030	27.69	r				
							***
·	54						· · · · · · · · · · · · · · · · · · ·
	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1						
Measured by:	R	Audited by:	5		Prototy	pe Approval:	N/A
Date:	10-1-14	Date:	colocle	4		Date:	N/A
Rev Date	Change New Issue				F	Revised by (J/DD A	Approved
A 08.10.20	I MAN 12206					WILL CAN	<u>LX</u>

	•								<b>.</b>	
W/O:			WC	ORK ORDER CHANG	GES				<u> </u>	•
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR	: Yes N	o <b>DQ</b> A	<b>\:</b>	_ Date: _	
	Resolution: Disposition: QA: N/C Closed:							Date:		
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC Corrective Action						ation Approval		Approval
	0.1.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
1										

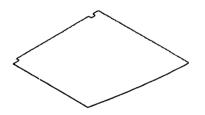
**D3788-1 CABIN FLOOR PROTECTOR** 



**D3788-3 CABIN FLOOR PROTECTOR** 



**D3788-2 CABIN FLOOR PROTECTOR** 



**D3788-4 CABIN FLOOR PROTECTOR** 



SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK CRDER NO. 54929 Pd 10-1-05



Α	NEW ISS	2115		PH	08.05.08
REV.	NEW 13	90E	DESCRIPTION	BY	DATE
DESIG	N	F4+	DART AEROS	SPACEL	TD
DRAW	N	Pot-	HAWKESBURY, ON	TARIO, CANAI	DA
CHECK	ED (33)	D.	DRAWING NO.		REV. A
MFG. A	PPR.	Wh	D3788		SHEET 1 OF 5
APPRO	VED	750	TILE		SCALE
DE API	PR.		CABIN FLOOR PR	OTECTO	DR NTS
DATE	0.80	5.08	COPYRIGHT © 2008 BY D THE COSSMECT OF PROVIDE AND CONFERENCE AND INCOME OF COME OF COM	NAMED TO ANY OTHER	CONDITION THAT IT &

W/O:		334-34		WORK ORDER	CHANGES		,		
DATE	STEP		PRO	CEDURE CHANGE	В	y Date	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
·		<u>g. 2000</u>							
Part No	):		PAR #:	Fault Category:	NCR: \	es No <b>D</b>	QA:	Date: _	

 Resolution: \_\_\_\_\_\_\_ Disposition: \_\_\_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_\_ Date: \_\_\_\_\_\_

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
DATE OTED		Description of NC		Corrective Action Section	В	Verification	Approval	Approval
DATE	STEP	Section A			Section C	Chief Eng	QC Inspector	
								ļ.
				· · · · · ·				
NOTE: D	ate & initial a	11						<u> </u>

- 36.50 7.38 R200.0 ---61.25 65.25 TEXTURED SIDE **-- 14.50 --**R0.25 TYP 46.60 **D3788-1 CABIN FLOOR PROTECTOR** DESIGN DART AEROSPACE LTD DRAWN pt HAWKESBURY, ONTARIO, CANADA MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK (REF DART SPEC MLEXS.125-F60029-04) CHECKED DRAWING NO. REV. A D3788 FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED MFG. APPR. SHEET 2 OF 5 TITLE APPROVED SCALE CABIN FLOOR PROTECTOR DE APPR BREAK SHARP EDGES: 0.005 TO 0.010 MAX IDENTIFICATION: IDENTIFY WITH DART P/N "D3788-1" USING FINE POINT PERMANENT INK MARKER OR LABEL ON SMOOTH SIDE WEIGHT: 15.02 lbs COPYRIGHT 6 2008 BY DART AEROSPA CE LTD
THE SOOMERT IS MENUTE AND COMPRISHED AN ONLY EXPRESS CONDITION TO BE USED FOR MENUTED TO MENUTED FOR MENUTED TO MENUTED TO MENUTED FOR DATE 08.05.08 3

N/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			

Part No:		PAR #:	Fault Category:	NCR: Yes No I	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:		Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							1	
								}
II.								

- 41.88 36.50 7.38 – R200.0 💃 61.25 65.25 TEXTURED SIDE - 14.50 R0.25 46.60 D3788-2 CABIN FLOOR PROTECTOR DESIGN DART AEROSPACE LTD IOTES:
) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK
(REF DART SPEC MLEXS.125-F60029-04)
) FINISH: NONE
) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
) UNITS: INCHES UNLESS OTHERWISE NOTED
) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
) IDENTIFICATION: IDENTIFY WITH DART P/N "D3788-2" USING FINE POINT PERMANENT INK MARKER OR LABEL ON SMOOTH SIDE
) WEIGHT: 15.02 lbs DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3788 MFG. APPR. SHEET 3 OF 5 TITLE APPROVED SCALE **CABIN FLOOR PROTECTOR** DE APPR DATE 08.05.08 5 7 8

W/O:

DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #: Fault Category: NC	R: Yes	s No <b>DQ</b>	A:	Date: _	

**WORK ORDER CHANGES** 

NCR:		,	WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
DATE OFF		Description of NC		Corrective Action Section B	; ;	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
		, and the second						
		1,470						

2.00 1.50 - 1.00 R200.0 -31.50 **TEXTURED SIDE-**2.13 R0.25 TYP - 1.00

**D3788-3 CABIN FLOOR PROTECTOR** 

) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK (REF DART SPEC MLEXS.125-F60029-04)

(REF DART SPEC MLEAS. 123-F00029-04)

1) FINISH: NONE

1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

1) UNITS: INCHES UNLESS OTHERWISE NOTED

1) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

1) IDENTIFICATION: IDENTIFY WITH DART P/N "D3788-3" USING FINE POINT PERMANENT INK MARKER OR LABEL ON SMOOTH SIDE

1) WEIGHT: 5.01 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3788 SHEET 4 OF 5

MFG. APPR. TITLE APPROVED DE APPR.

\*\*

CABIN FLOOR PROTECTOR

NTS

OUP ROHT 0 2008 BY DART AEROSPACE LTD

Nes DOUBLET OF THE TOTAL OUT OF THE TOTAL CONTROL NH IT IS

NOT TO BE USES FOR ANY PAPERS OF OWNER OF THE TOTAL PRESENCE WITHOUT PROPERSON WITH DATE 08.05.08

5

ž

.

. . . 5

8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		•						
1								

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	•	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification	Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
	1						Į.	Ì		

2.00 1.50 1.00 --R200.0 31.50 TEXTURED SIDE 2.13 R0.25 TYP 1.00 27.69

D3788-4 CABIN FLOOR PROTECTOR

IOTES:
) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK
(REF DART SPEC MLEXS.125-F60029-04)
) FINISH: NONE
) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
) UNITS: INCHES UNLESS OTHERWISE NOTED
) UNITS: INCHES UNLESS OTHERWISE NOTED
) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
| IDENTIFICATION: IDENTIFY WITH DART P/N "D3788-4" USING FINE POINT PERMANENT INK MARKER OR LABEL ON SMOOTH SIDE
) WEIGHT: 5.01 lbs

$\mathcal{U}_{0}$		2479			
DESIGN	få	DART AEROSPACE LTD			
DRAWN	pt	HAWKESBURY, ONTARIO, CANADA			
CHECKED	is?		EV. A		
MFG. APPR.		D3788 SHEET	SHEET 5 OF 5		
APPROVED		1	SCALE		
DE APPR.	-#-	CABIN FLOOR PROTECTOR	NTS		
DATE OR C	5.08	COPY RIGHT © 2006 BY DART AEROSPA CE LTD THE DOCUMENT IS PRINTE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS			

08.05.08

6

3,1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		**************************************						
					•	,		

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Corrective Action Section B			Approval	Approval		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector		
		•								
		·								